

Work Order ID 144519

April 19, 2016 2:38:48 PM

144519

Page 1

Item ID: D355-600-243

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

*SLT*Date: **20160419**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D355-600

Rev C

DAS
6
9-89

AUG 16 2016

*Pick kit*DAS
6
9-8921
9-89

AUG 16 2016

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D355-600-243 CHG002

16.08.31

110

Small Fab

0.00

110

Small Fab

Memo

6.32

Small Fab

1-Drill holes in D3188-1 using drill jig DT8970 2-Open holes in D3188-1 body floor to Ø0.297" as per dwg D3188 3-Deburr4-Install inserts in D3188-1 as per Dwg D3188.

16.08.31

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.02

Quality Control

D. DAS
116
9-9-89*16/08/31*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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144519

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Spacepod™ Fwd Opening LH AS355

Stop *NS2*

Start Date: 6/24/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

1-Cut D2986 Neoprene Foam per template D2986T1

140

0.00

140

Small Fab

0.00

Small Fab

Memo

Small Fab

this step seperates hardware, previous steps is for body & floor

L
16.08.3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 144519***144519***

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Item ID: D355-600-243

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Spacepod™ Fwd Opening LH AS355

Stop ***NS2***Start Date: 6/24/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Small Fab	0.00							
150									
Small Fab	Memo	0.00							
Small Fab	Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600 ***Hardware on previous steps is for door ass'y****								
	1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight								
	A/R Hysol batch: <u>M135461</u>								
	Primer B# <u>133641</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.02							
Quality Control									

16.08.31

Pto →

16.08.31

DAS
9
8-89

DQA:

Date: 09/16/21



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: SEP 14 2016

Work Order update only ☐

Work Order: 144514		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. D3J-600-243		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. 16-60001		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☒	Supplier ☐	
Date: 16/08/31		Step #: # 150		QTY Effective: 201		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				DAS 16 9-89 16/08/31	
Due to edge distance of 0.172" holes to fix door to pod to close to the Ribs. Build up of Hysol + Filler needs to be installed		install Hysol m135461 in locations of hinge holes in pod as per Q52037				Completed By 16-08-31	
						Lead hand / Supervisor Approval Verification	
						DAS 16 9-89 16/08/31	
						QC / QA Coordinator Approval	
						DAS 16 9-89 16/08/31	
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	☒ Fit/Function	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☒ Manufacturing Process						
Misidentified ☐	Past Due ☐	OTHER :					

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Page 4

Item ID: D355-600-243

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	HandFinishing	0.00							
170	Memo	0.00							
Hand Finish	Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005								
Hand Finishing	4.4Batch: <u>1134948</u>								
180	QC3- Inspect Part Finish	0.00							
180	Memo	0.01							
QC									
Quality Control									
190	QC4- 100% Inspect kits for completeness	0.00							
190	Memo	0.03							
QC									
Quality Control									

DAS 27 9-89
DAS 28 9-89
AUG 31 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Item ID: D355-600-243

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Spacepod™ Fwd Opening LH AS355

Stop ***NS2***Start Date: 6/24/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Packaging	0.00				DAS 28 9-89			
200									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D355-600-243 Location: _____								
	PPP Rev: _____								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.10				DAS 21 9-89			
Quality Control									

AUG 31 2016

AUG 31 2016

Lm 16/08/31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
2AG FC				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.11.27 new issue EC
IPP Rev:B 08-12-09 chg as per DSI9401 DD verified by:EC IPP REV:C
14.07.16 as per DSI9700 rev.a DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-6A *AN3-6A* Bolt		Purchased		No			Each	166.0000		7			
									**	134955			
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				DAS
					over003			75					6
					M134630			75					9-89
					ST349			91					
					M133932			1					
					M134055			90					
D5127-1 *D5127-1* Shim, Large		Manufactured		No			Each	28.0000		2			DAS
									**				6
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				9-89
					ST153			28					
					127406			8					
					128839			20					
D5127-3 *D5127-3* Shim, Small		Manufactured		No			Each	28.0000		2			DAS
									**				6
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				9-89
					ST153			28					
					127632			8					
					128941			20					

AUG 16 7:00

Picklist Print

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Page 2

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 AELS4-1032-130 Purchased No

110 Each 5,112.000 28 28

ALS4-1032-130

Rivnut

**

128649

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK005

4900

M134502

4900

FP001

212

M133077

212

D3015-3 Manufactured No

110 Each 351.0000 1 1

D3015-3

Locknut

**

146273

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

1

136803

1

ST025A

332

141459

32

141800

100

141898

200

D3186-3 Manufactured No

110 Each 0.0000 1 1

D3186-3

Spacepod Door, LH

**

3144520

DAS
02
9-89

16-06-16

D3187-1 Manufactured No

110 Each 4.0000 1 1

D3187-1

Floor Panel

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST400

4

59334

4

AUG 16 2016

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3188-3M Manufactured No

110 Each

0.0000 1 1

D3188-3M

Spacepod Body LH (355)

A3235-020-935

Purchased No

130 Each

143.0000 8 8

A3235-020-935

Washer, Countersunk

DAS
02
9-89

16-08-16

DAS
6
9-89

Location

Loc Qty

Loc Code

ST548

23

106150

23

ST554

120

m133932

20

m134370

100

D2179 Manufactured No

140 Each

22.0000 2 2

D2179

Hinge Bracket Plate

**

DAS
6
8-89

Location

Loc Qty

Loc Code

ST003

21

106233

21

ST004

1

35432

1

D2237 Manufactured No

140 Each

20.0000 2 2

D2237

Striker Plate

**

1455/6

DAS
6
8-89

Location

Loc Qty

Loc Code

ST004

20

140960

20

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Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3015-3

Manufactured No

140

Each

351.0000

1

1

**

146273

DAS
6
9-89

D3015-3

Locknut

Location

Loc Qty

Loc Code

FG
95758
96151
ST015
136803
ST025A
141459
141800
141898

18
8
10
1
1
332
32
100
200

D3538-1

Manufactured No

140

Each

25.0000

2

2

**

DAS
6
9-89

D3538-1

Hinge Bracket

Location

Loc Qty

Loc Code

FG
115602
130855
ST041
130855
141380

4
2
2
21
1
20

AUG 16 2016

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Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3554-7

Manufactured No

140

Each

17.0000

1

1

D3554-7

Ball Stud

**

Location

Loc Qty

Loc Code

FG

5

87039

5

ST042

10

142010

10

ST049

2

87571

2

D3567-1

Manufactured No

140

Each

12.0000

1

1

D3567-1

Decal

**

Location

Loc Qty

Loc Code

ST043

12

130993

12

D3722-1

Manufactured No

140

Each

38.0000

2

2

D3722-1

Spacer Wedge

**

Location

Loc Qty

Loc Code

Mezz

38

55342

38

MS20426AD4-5

Purchased No

140

Each

1,816.000

4

4

MS20426AD4-5

RIVET

**

Location

Loc Qty

Loc Code

GA

1316

m133751

1316

ST312

500

m133751

500

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Page 5

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89
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Page 6

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039C0-827

Purchased

No

140

Each

12.0000

4

4

MS27039C0-827

SCREW

**

DAS

6

9-89

Location

Loc Qty

Loc Code

Mezz

12

106298

12

NAS1149D0563J

Purchased

No

140

Each

1,509.000

1

1

NAS1149D0563.J

Washer

**

1,350.58

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

279

m125807

2

m133769

277

ST260a

1000

m134497

1000

ST263

131

m134257

131

ST269

99

m128257

99

NAS1149DN816J

Purchased

No

140

Each

313.0000

4

4

NAS1149DN816.J

WASHER

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST265

313

m128057

313

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Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

140

Each

1,579.000

4

4

NAS1149DN832J

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST265

1495

M134180

1495

AN526C832R10

Purchased

No

150

Each

65.0000

8

8

AN526C832R10

Screw

DAS
6
9-89

Location

Loc Qty

Loc Code

ST328

65

m127363

65

AN526C832R14

Purchased

No

150

Each

170.0000

2

2

AN526C832R14

Screw

DAS
6
9-89

Location

Loc Qty

Loc Code

ST327

170

124215

20

m133932

150

D2228

Manufactured

No

150

Each

36.0000

4

4

D2228

Backing Plate

DAS
6
9-89

Location

Loc Qty

Loc Code

ST004

7

95704

7

ST012a

29

105984

29

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Page 7

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Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

D2464 Manufactured No 150 f 786.1337 10.8 11.36842

D2464

Neoprene Seal (\$per foot)

DAS
6
9-89

Location

Loc Qty

Loc Code

ST409

786.1336842

121946

786.133684

D2585 Manufactured No 150 Each 65.0000 2 2

D2585

Latch Clamp

146078

DAS
6
9-89

Location

Loc Qty

Loc Code

ST008

65

142882

65

D2586 Manufactured No 150 Each 70.0000 2 2

D2586

Door Latch

Location

Loc Qty

Loc Code

FG

12

119746

1

138048

2

139228

9

ST481

8

139228

8

ST488a

50

140535

25

141454

25

2

DAS
6
9-89

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Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

D2621

Manufactured No

150

Each

33.0000

2

2

D2621

Latch Plate

Location

Loc Qty

Loc Code

FG

2

88616

2

ST009

31

127749

1

141106

20

142793

10

DAS
6
9-89

D2857-1

Manufactured No

150

Each

15.0000

1

1

D2857-1

Hinge Bracket

Location

Loc Qty

Loc Code

FG

5

121829

2

82261

2

91914

1

ST012a

10

141046

10

DAS
6
9-89

D2857-2

Manufactured No

150

Each

17.0000

1

1

D2857-2

Hinge Bracket

Location

Loc Qty

Loc Code

FG

3

78904

3

ST012a

14

140972

14

DAS
6
9-89

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Picklist Print

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Page 10

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3557-1

Manufactured No

150

Each

11.0000

1

1

D3557-1

Bracket

Location

Loc Qty

Loc Code

ST049

11

125281

1

126308

10

D3567-1

Manufactured No

150

Each

12.0000

1

1

D3567-1

Decal

Location

Loc Qty

Loc Code

ST043

12

130993

12

MS21042L08

Purchased No

150

Each

1,029.000

4

4

MS21042L 08

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

319

m133134

3

m134063

316

ST303

237

m133922

37

m134574

200

ST308

372

m134376

372

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

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Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,699.000

2

2

MS21042L3

Nut

135056

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

782

m133790

3

m134360

779

ST304

817

m134039

12

m134360

805

MS27039-08-11

Purchased

No

150

Each

223.0000

2

2

MS27039-08-11

SCREW

DAS
6
9-89

Location

Loc Qty

Loc Code

ST278

223

m133769

223

2

MS27039-1-15

Purchased

No

150

Each

337.0000

2

2

MS27039-1-15

Screw

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

21

m127916

21

ST280

316

m132640

316

2

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Picklist Print

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Page 12

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

150

Each

2,049.000

2

2

NAS1149D0363.J

Washer

**

134955

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

583

m134055

583

ST260a

1000

m134606

1000

ST263

466

m134370

466

NAS1149DN832J

Purchased

No

150

Each

1,579.000

4

4

NAS1149DN832.J

Washer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST265

1495

M134180

1495

NAS1515H3

Purchased

No

150

Each

346.0000

2

2

NAS1515H3

Washer

**

AUG 16 2016

Location

Loc Qty

Loc Code

FG

10

123301

10

GA

38

m129521

38

ST260

298

m128635

7

m131697

291

DAS
6
9-89

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Picklist Print

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Page 13

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

AN526C832R10

Purchased

No

190

Each

65.0000

2

2

AN526C832R10

Screw

**

Location

Loc Qty

Loc Code

ST328

65

m127363

65

190

Each

11.0000

1

1

D2985

Manufactured

No

**

D2985

Label

Location

Loc Qty

Loc Code

ST014

11

131782

11

190

Each

2.0000

1

1

D350-600-449

Manufactured

No

**

D350-600-449

Switch Relocation

Location

Loc Qty

Loc Code

FG125

2

132506

1

137505

1

190

Each

20.0000

1

1

D3547-1

Manufactured

No

**

D3547-1

Bracket

Location

Loc Qty

Loc Code

ST042

20

106211

20

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Page 14

Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

D3550-1 Manufactured No

190 Each 5.0000 1 1

D3550-1

Strut

DAS
6
9-89
DAS
28
9-89

Location Loc Qty Loc Code

ST358 5

127799 5

D3552-7 Manufactured No

190 Each 11.0000 1 1

D3552-7

Door Prop

DAS
28
DAS
6
9-89

Location Loc Qty Loc Code

FG 1

118882 1

ST363 10

132282 2

142255 8

D3554-7 Manufactured No

190 Each 17.0000 1 1

D3554-7

Ball Stud

DAS
28
DAS
9
9-89

Location Loc Qty Loc Code

FG 5

87039 5

ST042 10

142010 10

ST049 2

87571 2

K10021 Manufactured No

190 Each 1.0000 1 1

K10021

Spacepod Hardware (-241)

DAS
6
9-89

DAS
28
9-89

Location Loc Qty Loc Code

FG125 1

134942 1

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Picklist Print

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Work Order ID: 144519

144519

Parent Item: D355-600-243

D355-600-243

Parent Item Name: Spacepod™ Fwd Opening LH AS355

Start Date: 6/24/2016

Required Date: 7/5/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

190

Each

1,509.000

2

2

NAS1149D0563.J

Washer

135058

DAS
28

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	279	
m125807	2	
m133769	277	
ST260a	1000	
m134497	1000	
ST263	131	
m134257	131	
ST269	99	
m128257	99	

AUG 16 2016

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-600 REV. E OR EARLIER

AND ICA-D350-600 REV. 5 OR EARLIER

REF TCCA STC: SH93-88

REF FAA STC: SR00098NY/SR00099NY

REF EASA STC: EASA.IM.R.S.01292

1.0 PURPOSE:

IT HAS COME TO DART'S ATTENTION THAT THE INFORMATION SHOWN ON D2985 DECAL CAN BE MISINTERPRETED WHEN ONLY A LH OR RH SPACEPOD IS INSTALLED ON AN AIRCRAFT. THEREFORE, THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO ADD THE D2985-1/-3 DECALS AS OUTLINED BELOW.

2.0 INSTRUCTIONS:

IT IS ACCEPTABLE TO REPLACE D2985 WITH D2985-1/-3 AS FOLLOWS:

D2985-1: FOR LH INSTALLATIONS ONLY (REF. D35X-600-141/-143/-241/-243)

D2985-3: FOR RH INSTALLATIONS ONLY (REF. D35X-600-142/-242)

3.0 PARTS LIST

QTY -141	QTY -142	QTY -143	QTY -241	QTY -242	QTY -243	PART NUMBER	DESCRIPTION
X						D350-600-141	SPACEPOD... LH, AS350
	X					D350-600-142	SPACEPOD... LH, AS350/AS355
		X				D355-600-143	SPACEPOD... LH, AS355
			X			D350-600-241	SPACEPOD... LH, AS350
				X		D350-600-242	SPACEPOD... LH, AS350/355
					X	D355-600-243	SPACEPOD... LH, AS355

1	1	1	1	1	1	D2895	DECAL
1		1	1		1	D2895-1	LH DECAL (ADD)
	1			1		D2895-3	RH DECAL (ADD)

4.0 WEIGHT AND BALANCE

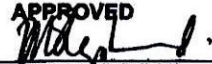
NO CHANGE.

5.0 MAINTENANCE:

MAINTAIN D2985-1/-3 PER ITEM 5.2.7 OF ICA-D350-600.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.12.07

CERT. NO.: SH93-88

ISSUE NO.: 6

A	NEW ISSUE	SFM	12.12.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9639	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DECAL CHANGE	NTS
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